

Date: Wednesday, 3/8/2006 2:03:50 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 26165		
Estimate Number	: 11040		
P.O. Number	: N/A	Part Number	: D28042
This Issue	: 3/8/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2804 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25930	Drawing Revision	: B
		Type	: SMALL /MED FAB
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/15/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	4 Um: Each
Comment	: Est. A00.11.06 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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u060312



Comment: Qty.: 0.7875 f(s)/Unit Total: 3.1500 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M10046

JUL 06/03/10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks per template DT8534

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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SEE ATTACHED

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 2:03:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 26165

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. 06-03-13

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/14

Job Completion



u 06-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

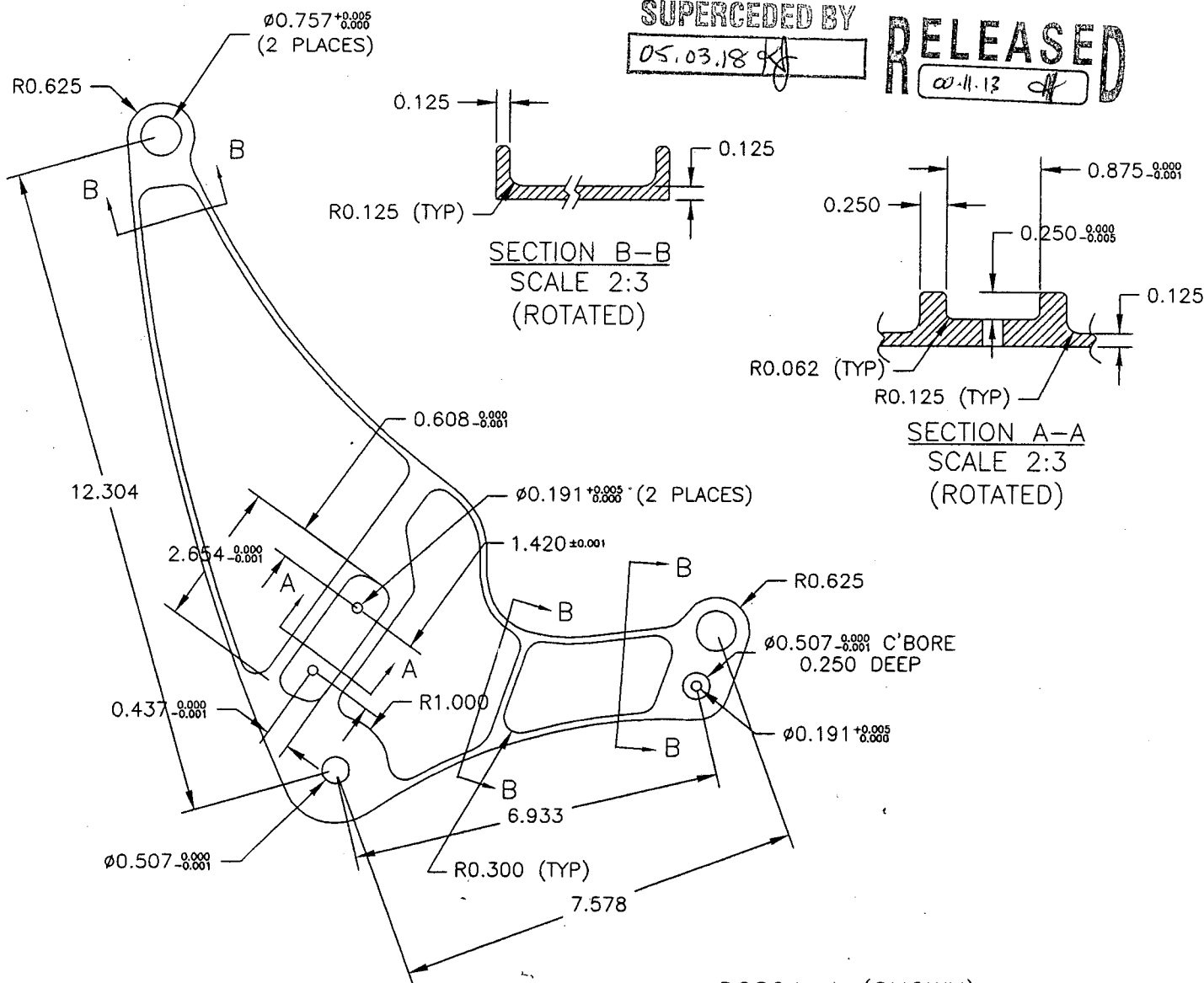
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 <i>[Signature]</i>	

SUPERCEDED BY

05.03.18 *[Signature]*RELEASED
00.11.13 *[Signature]*D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK

DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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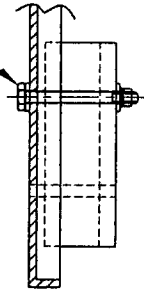
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 155 BRACKET		SCALE 1:3

RELEASED
00.11.13 #

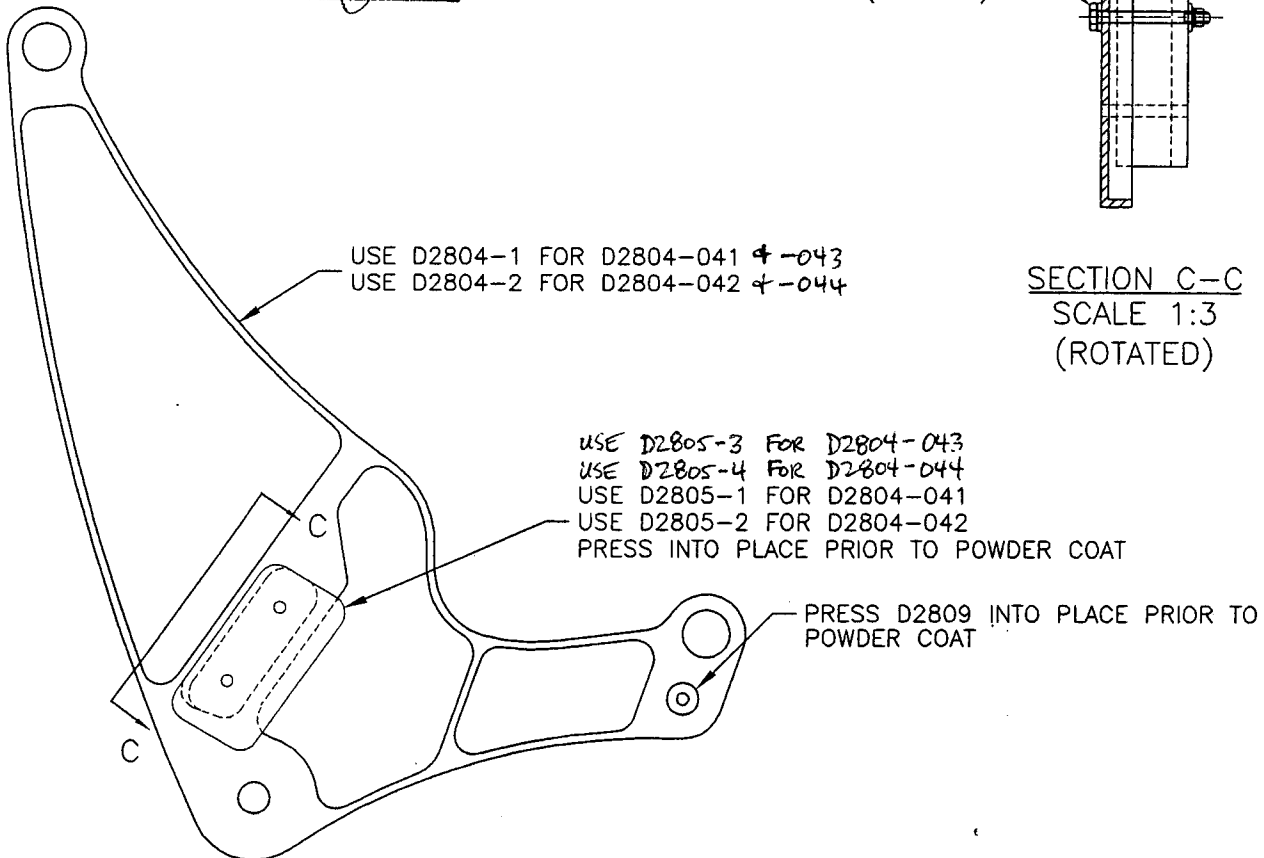
SUPERCEDED BY

05.03.18 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order:	
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.129	✓			
R0.125	+/-0.010	R0.125	—			
0.250	+/-0.010	0.249	—			
0.250	+0.000/-0.005	0.246	—			
0.875	+0.000/-0.001	0.8745	✓			
R0.062	+/-0.010	R0.062	—			
Ø0.757	+0.005/-0.000	Ø0.759	—			
R0.625	+/-0.010	R0.625	✓			
12.304	+/-0.005	12.305	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
0.437	+0.000/-0.001	0.436	✓			
0.608	+0.000/-0.001	0.608	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	0.250	—			
6.933	+/-0.005	6.933	—			
7.578	+/-0.005	7.577	✓			

Measured by:	<i>JML</i>	Audited by:	<i>J.L</i>	Prototype Approval:	N/A
Date:	06/03/10	Date:	06-03-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	

OLD STYLE

Dart Aerospace Ltd.

Date: Wednesday, 3/8/2006 2:03:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 26165	
Estimate Number : 11040	
P.O. Number :	Part Number : D28042
This Issue : 3/8/2006 S.O. No. :	Drawing Number : D2804 REV B/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 25930	Material :
Written By :	Due Date : 3/15/2006 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est. A00.11.06 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.7875 f(s)/Unit Total: 3.1500 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M10046

JML 06/03/10

4

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** BAND SAW

Cut blanks per template DT8534

JML 06/03/10

4

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

JML 06/03/10

4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JML 06/03/10

4

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

JML 06/03/10

4

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

JML 06/03/10

4

REFERENCE ONLY

Date: Wednesday, 3/8/2006 2:03:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 26165

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG

06.03.13

4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/14

4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 06/03/14 4

Job Completion



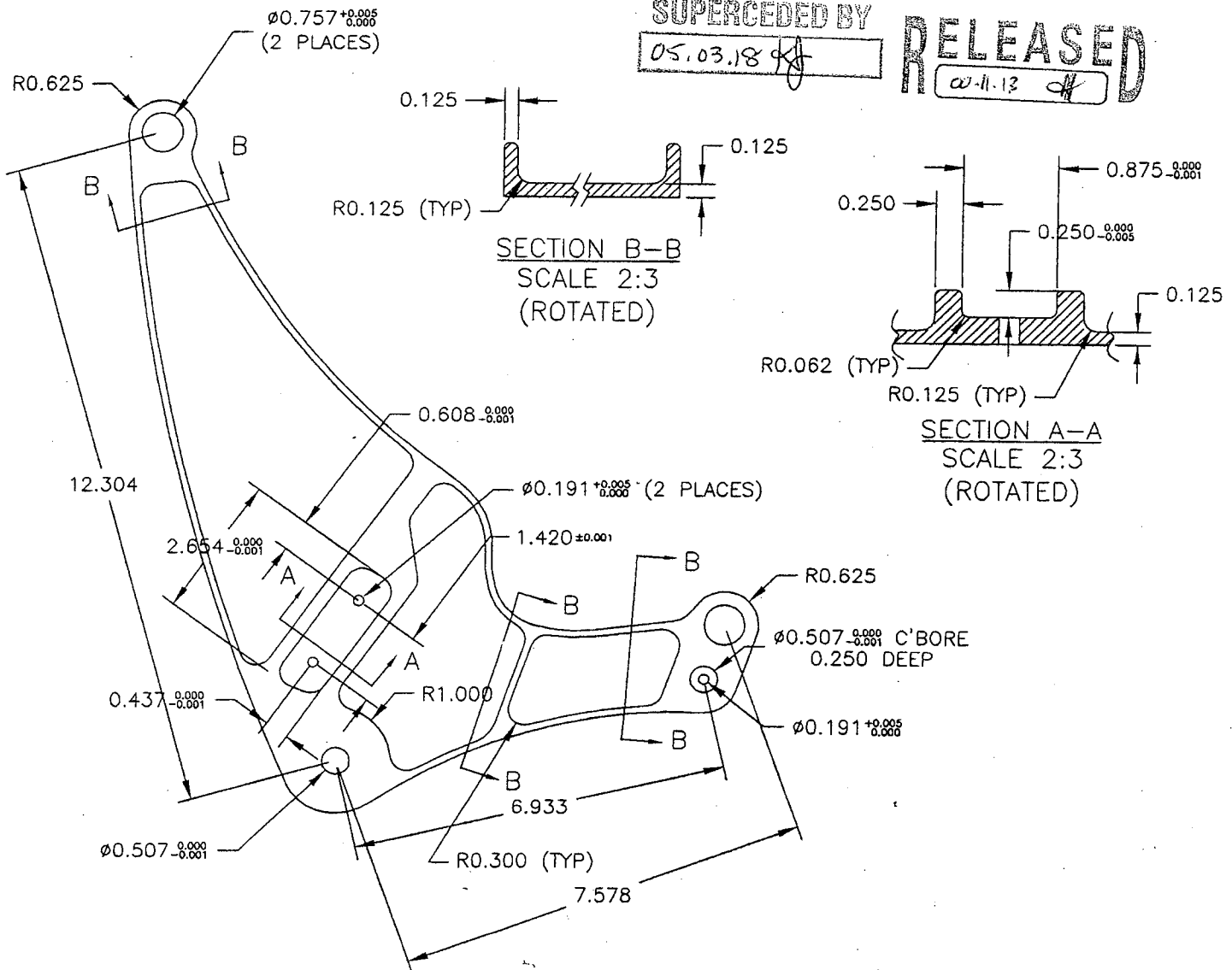


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 # CP	

SUPERCEDED BY

05.03.18 #

RELEASED
01.11.13 #



D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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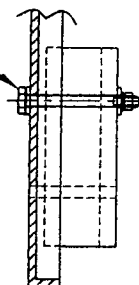
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED
00.11.13 #

SUPERCEDED BY

05.03.18 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041 & -043
USE D2804-2 FOR D2804-042 & -044

USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order:	
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.129	—			
R0.125	+/-0.010	R0.125	—			
0.250	+/-0.010	0.249	—			
0.250	+0.000/-0.005	0.246	—			
0.875	+0.000/-0.001	0.8745	—			
R0.062	+/-0.010	R0.062	—			
Ø0.757	+0.005/-0.000	Ø0.759	—			
R0.625	+/-0.010	R0.625	—			
12.304	+/-0.005	12.305	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
0.437	+0.000/-0.001	0.434	—			
0.608	+0.000/-0.001	0.608	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
1.420	+0.001/-0.001	1.420	—			
0.250 deep	+/-0.010	0.250	—			
6.933	+/-0.005	6.933	—			
7.578	+/-0.005	7.577	—			

Measured by:	<i>JML</i>	Audited by:	J.L	Prototype Approval:	N/A
Date:	06/03/10	Date:	06-03-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries